

Date: Thursday, 22/01/2009 8:00:25 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number :	45040		
Estimate Number :	13434		
P.O. Number :		Part Number :	PB674300117
This Issue :	22/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.7
First Issue :	/ /	Project Number :	N/A
Previous Run :	43058	Drawing Revision :	B1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	28/01/2009
Written By :		Qty:	9
		Um:	Each
Checked & Approved By :	mf 09-01-22		
Comment :	Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001259	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube

batch: 44979

mf 09-02-18

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube Bushing

batch: 1x 41877, B 44984 x 8

mf 09-02-18

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B 44992 x 1, B 44983 x 8.

mf 09-02-18

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B 44982

mf 09-02-18

5.0	PB674300171	PB67-43001-71
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

PB67-43001-71

batch: B 44512

mf 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45040

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(X9)

Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

Cpl 09.02.20

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BF 09/02/23 (9K)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

done

20902.23 (9)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

HELICAL INSERT

m 110768

MF 09-02-18

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

Cpl 09.02.24

(X9)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/24 (X9)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

m 18144

FL 09/03/03

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 45040

Part Number: PB674300117

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

6:25

OVEN TEMPERATURE:

320°

FINISH TIME:

6:55

FL 09/03/04 (9)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 09-03-14 (9)

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

20 Degree Cover Plate

batch: 40094 x 6, B 41513 x 3

MF 09-03-05

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

PB67-43001-83

batch: 1 x 95008, 8 x 45072

MF 09-03-11

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 72.0000 Each(s)

Screw

batch: M110704

MF 09-03-05

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 72.0000 Each(s)

WASHER

batch: M110704

MF 09-03-05

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

M.H 09/03/06 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090309

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST Blade Fold section. MF 09-03-11

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



MF 09-03-11

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

